

Work Order ID 85622

85622

Page 1

June-12-12 8:51:42 AM

Item ID: D2563

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Step Weldment Assembly

Stop ***NS2***

Start Date: 12/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563								
	2-Deburr ends								
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343								
	4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

6 φ Ae
12.06.26
ll
12.07.05

*6 φ 1207/18 DAS 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS
16

12/07/19

120

QC

Memo

0.00

Quality Control

14

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

6X

MT
12/07/19

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

6

12/12/19

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Aluminum rod Batch: 120854 0.00

150

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remaining End cap as per Dwg D2563 using DT 8343

3-Grind

6 0 12-07-24
Ae
12-07-25

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

DAS 16 12/12/26

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS 15 12/12/26

(14)

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175 *175* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Touch up Alodine as per QSI005	0.00 0.00				6x Ø			mt 12/07/26
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 12:45 OVEN TEMPERATURE: 320°F FINISH TIME: 1:15	0.00 0.00				6x Ø			mt 12/07/26
190 *190* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M12161300 Memo	0.00				6x Ø			mt 12/04/30

M121841

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Process Plan:

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

6 8 20 12/07/30

210

Identify as per dwg & Stock Location: _____

0.00

210

Packaging

Memo

PPP 85621

0.00

Packaging

Per 12/8/11 (6)

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/8/12

ML5 12/08/11

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Picklist Print

June-12-12 8:51:47 AM

Page 1

Work Order ID: 85622

85622

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured No

100

Each

76.5000

1

6

D2244-116

Step Extrusion

**

~~883894~~

~~26~~

Ac
12.06.26

Location

Loc Qty

Loc Code

WA

76.5

80803

76.5

D2561

Manufactured No

100

Each

44.0000

2

12

D2561

Lug

**

~~6~~

12.07.04

Location

Loc Qty

Loc Code

WA

39

80813

13

84326

26

WA015

5

66813

5

D2564

Manufactured No

100

Each

40.0000

2

12

D2564

Mounting Angle

**

12.07.04

Location

Loc Qty

Loc Code

WA

40

83429

24

83712

16

8
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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June-12-12 8:51:47 AM

Page 2

Work Order ID: 85622

85622

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 6.00

Required Qty: 6.00

D2673-34

Manufactured No

100

Each

91.0000

1

6

D2673-34

End Plate

**

Pl 12.07.05

Location

Loc Qty

Loc Code

WA

91

81468

2

84535

89

D2673-34

Manufactured No

150

Each

91.0000

1

6

D2673-34

End Plate

**

Pl 12.07.24

Location

Loc Qty

Loc Code

WA

91

81468

2

84535

89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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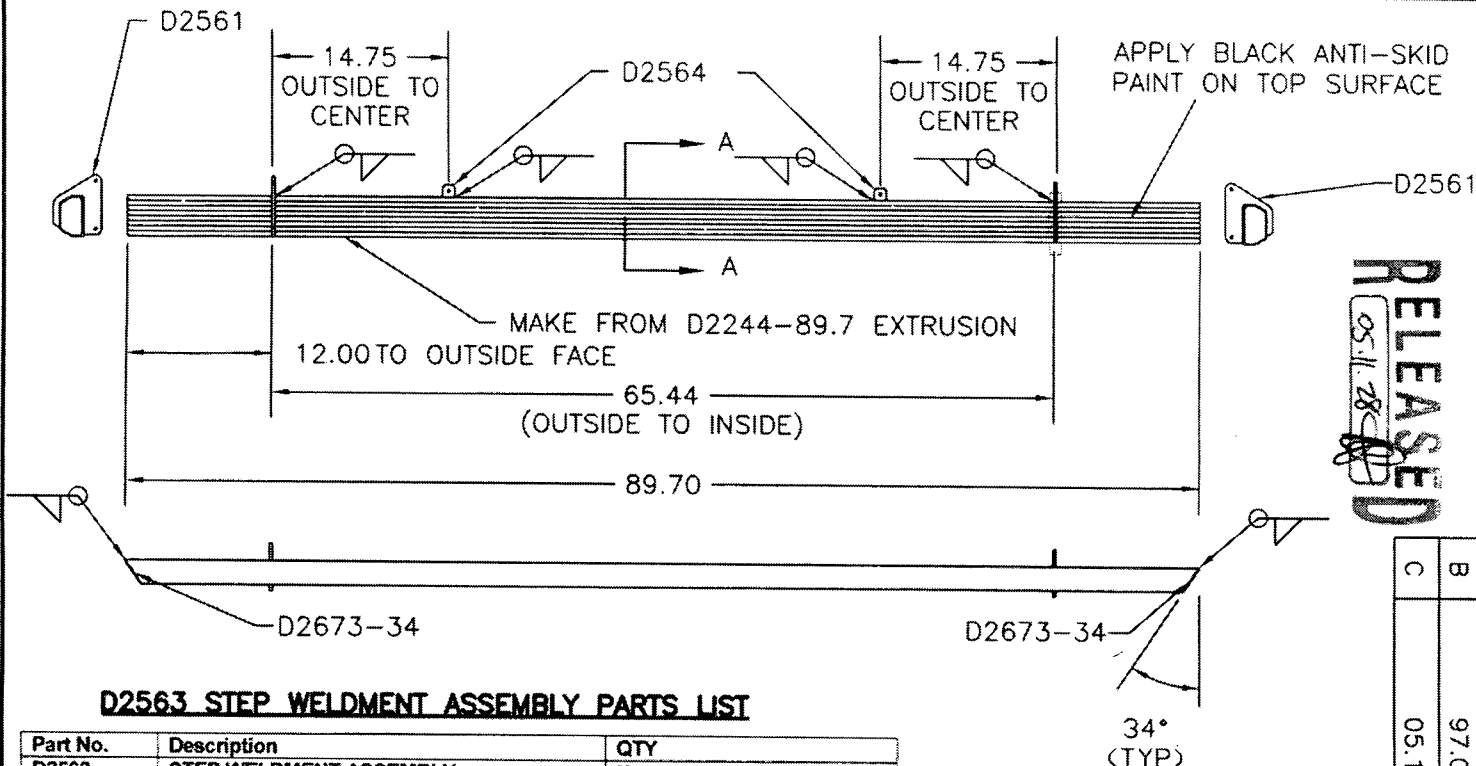
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RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	44	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
#	#	D2563	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. ESG22 MCLJ

12/06/12

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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